

*list*

Date: Monday, 23/02/2009 7:22:07 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	GAS SPRING
<b>Job Number</b> :	45932		
<b>Estimate Number</b> :	12941		
<b>P.O. Number</b> :		<b>Part Number</b> :	D355211
<b>This Issue</b> :	23/02/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3552 REV C
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	42606	<b>Drawing Revision</b> :	C
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	25/02/2009
<b>Written By</b> :	<i>[Signature]</i>	<b>Qty:</b>	20
<b>Checked &amp; Approved By</b> :	<i>[Signature]</i>	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:A New Issue 06-11-13 EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** Issue P/O: *9246*  
Purchase Part Number: B8-240-575-150N  
Supplier: LS Technologies  
Certificate of conformity is required

*C209/02/23*  
*(20)*

2.0	B8 240 575 150N
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
CARBON STEEL GAS SPRING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
Receive & Inspect For Transit Damage  
Ensure certificate of conformity is attached

*C209/02/25*

*(20)*

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Test for correct pressure

*351b's*

*S 08/02/25*

*counter*

*(+20)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*5T272*

*SS 09/02/26 (20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 23/02/2009 7:22:08 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 45932

Part Number: D355211

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/26

*[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.02.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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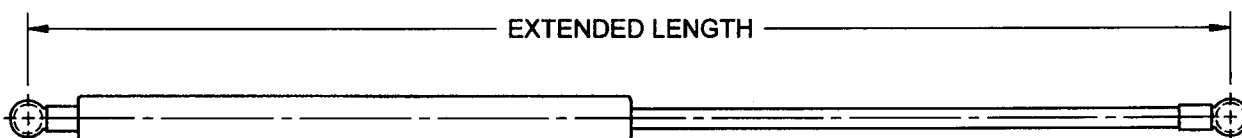
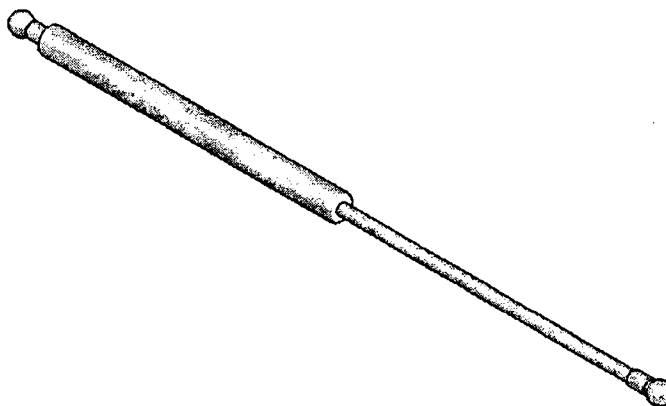
**NOTE:** Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>TH</i>	DRAWING NO. <b>D3552</b>	REV. C SHEET 1 OF 1
DATE <b>07.06.01</b>		TITLE <b>GAS SPRING</b>	SCALE NTS
REV	DATE	DESCRIPTION	
A	06.09.15	NEW ISSUE	
B	06.10.24	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	
C	07.06.01	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	

**RELEASED**  
07.07.11  
PER BAW #1001

## SPECIFICATION CONTROL DRAWING



### D3552-X GAS SPRING

DART P/N	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	LS TECHNOLOGIES P/N
D3552-1	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	C8-220-530-070N
D3552-3	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	C8-200-490-200N
D3552-5	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	C8-175-430-150N
D3552-7	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	B6-220-530-070N
D3552-9	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	B8-200-490-200N
D3552-11	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	B8-240-575-150N

**NOTE:**

1) IDENTIFY WITH DART P/N "D3552-X" USING WHITE FINE POINT PERMANENT INK MARKER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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## Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

**20 Units: B8-240-575-150N Carbon Steel Gas Spring**

Country of Manufacture: Canada  
Date of Manufacture : 2009  
This product is ROHS compliant.

S  
09/02/25

We certify no mercury was used in the manufacture of this order.

Purchase Order # 00008246  
Invoice # 4781

L S Technologies Inc Canada

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Nolan Fehr  
Manager